

Date: Wednesday, 2/15/2006 3:46:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FORWARD CAP			
Job Number	: 25839						
Estimate Number	: 10501						
P.O. Number	: N/A			Part Number	: D2744		
This Issue	: 2/15/2006	S.O. No.	N/A	Drawing Number	: D2744 REV B 1		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type	MACHINED PARTS	Drawing Revision	: B 1	
Previous Run	: N/A			Material	: N/A		
Written By	: SEE COMMENT BELOW			Due Date	: 3/15/2006		
Checked & Approved By	: JL 06.02.16			Qty:	30	Um: Each	
Comment	: Est C 03.01.17 Reformat; Dwg revised KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet
		Comment: Qty.: 0.1914 sf(s)/Unit Total : 5.7425 sf(s) Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick. Use off-cuts M5052H32S.080) Batch <u>119729</u> JL 06.02.24
2.0	SHEAR	SHEAR
		Comment: SHEAR <u>6.63"</u> <u>06.02.24</u> Cut blanks: <u>(2.400" x 3.125")</u> JL 06.02.24 30
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio FA309 and Dwg D2744 Deburr <u>SQD 06.02.27</u> JL 06.02.24 30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL 06.02.24 30
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK JL 06.02.24 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 060217
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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J 06/02/27 30

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA/LG

7.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

S 06/02/27

Job Completion



U 06-02-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25839
Description: Cap	Part Number:	D2744
Inspection Dwg: D2744 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	E.P.	Prototype Approval:	N/A
Date:	06.02.24	Date:	26.02.24	Date:	N/A

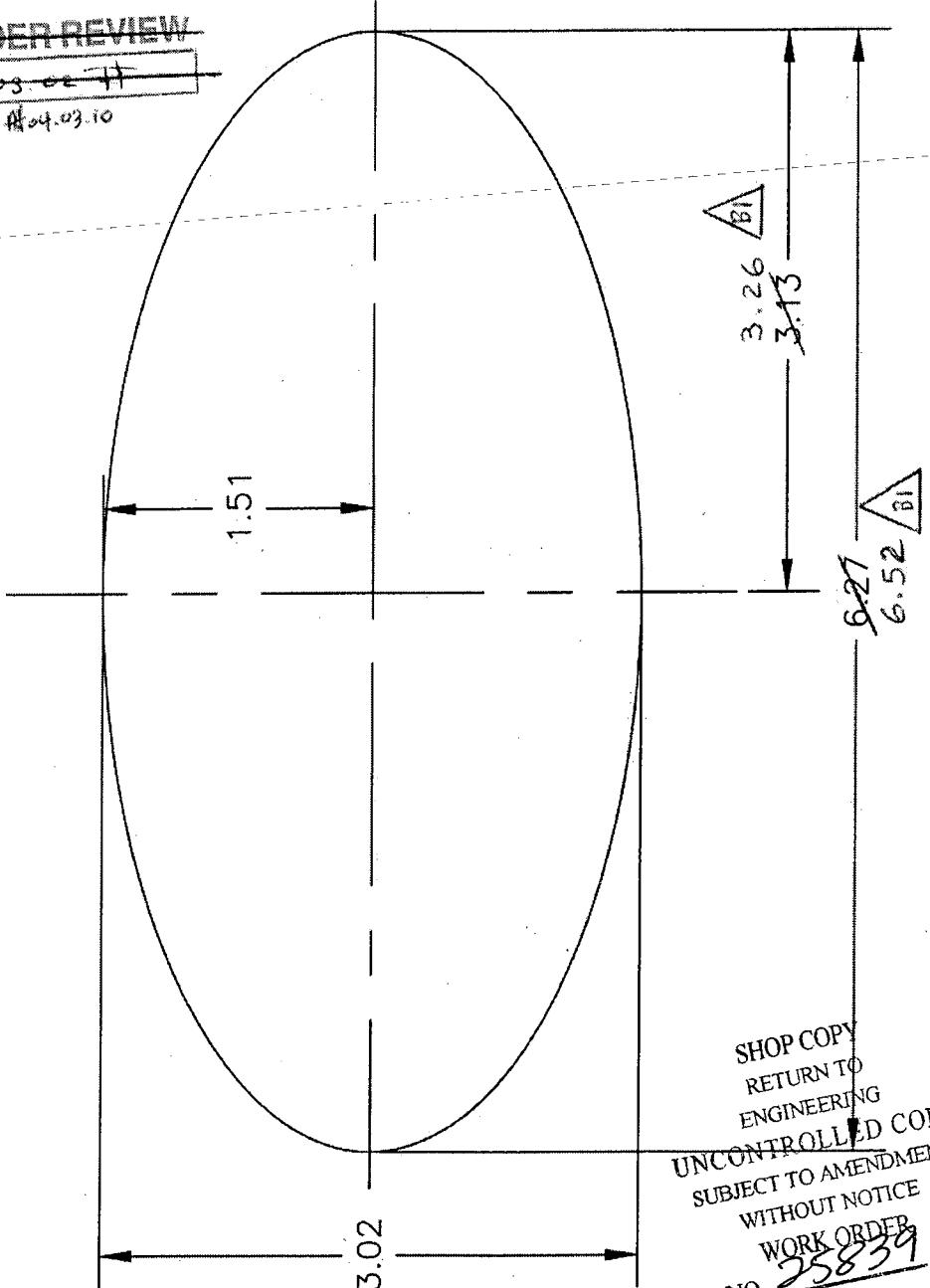
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.22	Dimension 6.52 was 6.27	KJ/RF	

DART

DESIGN <i>A</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2744	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	02.12.18	REDESIGN	
B1	04.03.10	6.52 WAS 6.27; 3.26 WAS 3.13	

RELEASED
02.12.18 ~~#~~**UNDER REVIEW**04.03.02 ~~#~~

OK # 04.03.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *25839*

NOTES

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK
(REF. DART SPEC M6061T6S.080 OR M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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